

Date: Monday, 09/03/2009 1:42:00 PM
 User: Julie Dawson

Process Sheet

| | | | |
|----------------------------------|---|-------------------------|---------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : WEARPLATE |
| Job Number | : 46326 | | |
| Estimate Number | : 10299 | | |
| P.O. Number | : | Part Number | : D25775 |
| This Issue | : 09/03/2009 | S.O. No. | : |
| Prsht Rev. | : NC | Drawing Number | : D2577 REV E |
| First Issue | : / / | Project Number | : N/A |
| Previous Run | : 32650 | Drawing Revision | : E |
| | Type : SMALL / MED FAB | Material | : |
| Written By | : | Due Date | : 31/03/2009 |
| Checked & Approved By | : <u>JUD 09.03.09</u> | Qty: | 10 Um: Each |
| Comment | : Est: F 02.09.24 Re-format KJ/RF Est Rev:D Now on Waterjet 06-06-14 JLM | | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|------------|----------------------|
| 1.0 | M1010S16GA | 1010/1025 sheet 16GA |
|-----|------------|----------------------|



Comment: Qty.: 1.0301 sf(s)/Unit Total: 10.3005 sf(s)
 1010/1025 16GA SHEET
 (m1010s16ga)
 Batch: 105706 13 9-3-12

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET
 1-Cut as per Dwg D2577
 Dwg Rev: E
 Prog Rev: E

13 9-3-12

2-Deburr if necessary 13 9-3-12

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: DIMENSIONAL CHECK
 Inspect dimensions per template D2577-5T1

13 9-3-12

11

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|

**Comment:** SECOND CHECK

0903.12 11

| | | |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr

N/A

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 09/03/2009 1:42:00 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 46326

Part Number: D25775

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on brake using DT8155 and DT8179 as per Dwg D2577

2-Form joggle using DT8157 as per Dwg D2577

3-Identify as D2577-5

SB 07/03/16 (11)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/03/16 (10)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

13:05

OVEN TEMPERATURE:

320°

FINISH TIME:

13:35

UMP/FL

(11)

09/03/17

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-17

(11)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

W22

09/03/17 (11)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/18

Job Completion



MF 09-03-18

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
|-------------------------------|--------------------------------|---|------------------------|
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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2577 | REV. E SHEET 1 OF 5 |
| DATE 00.09.22 | | TITLE WEARSHOE | SCALE 1:10 |
| A | 96.09.16 | NEW ISSUE | |
| B | 96.12.04 | ADD HARDCOAT WELDS | |
| C | 97.05.30 | CHANGE HOLES TO OBOUNDS | |
| D | 98.08.17 | CORRECTED DIMENSIONS ON -1 & -3 | |
| E | 00.09.22 | ADD D2577-101/-11/-13 INCORPORATE DE09176 | |

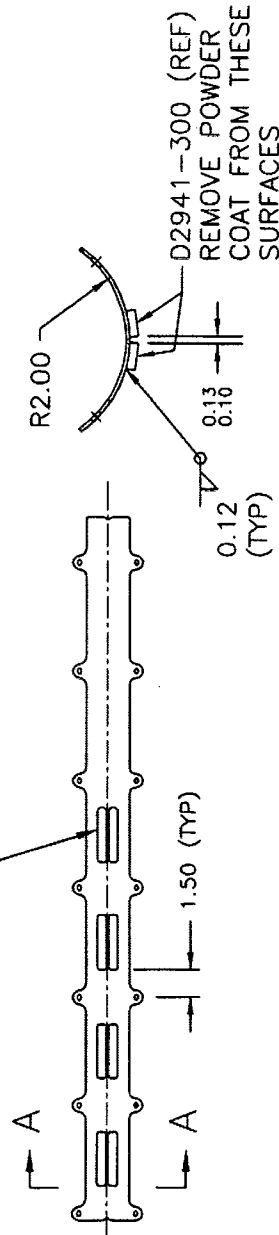
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00.09.22

7560 HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308

D2577-1 & D2577-3 WEARSHOE
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE
WORK ORDER
NO. 46326
D2577-101/-11/-13
SHWAYDER WEARPADS
(8 PLACES)

SECTION A-A
SCALE 1:5



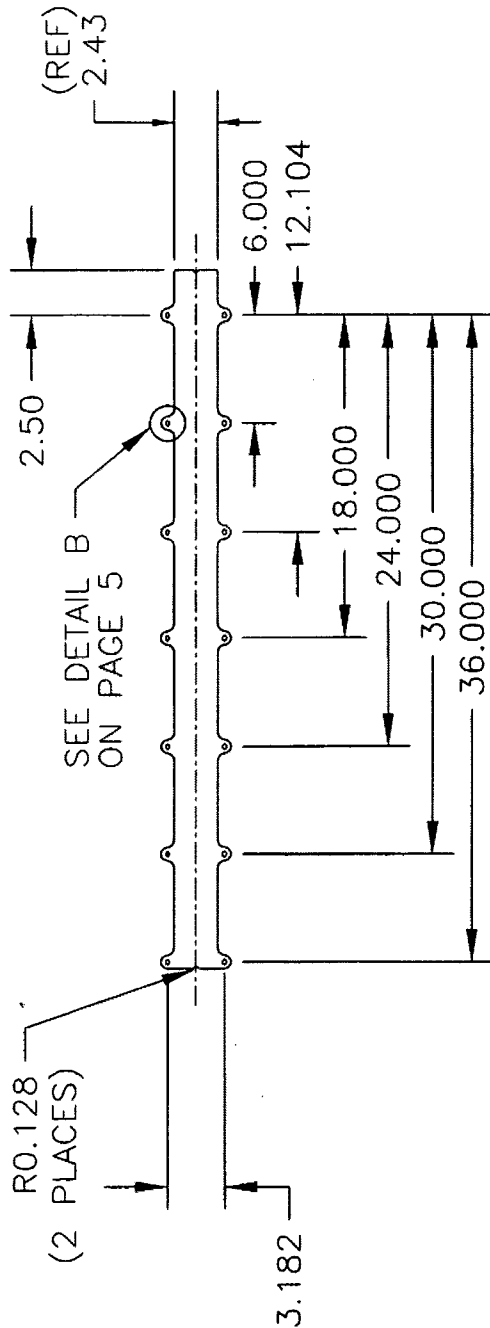
D2577-21 & D2577-23 WEARSHOE
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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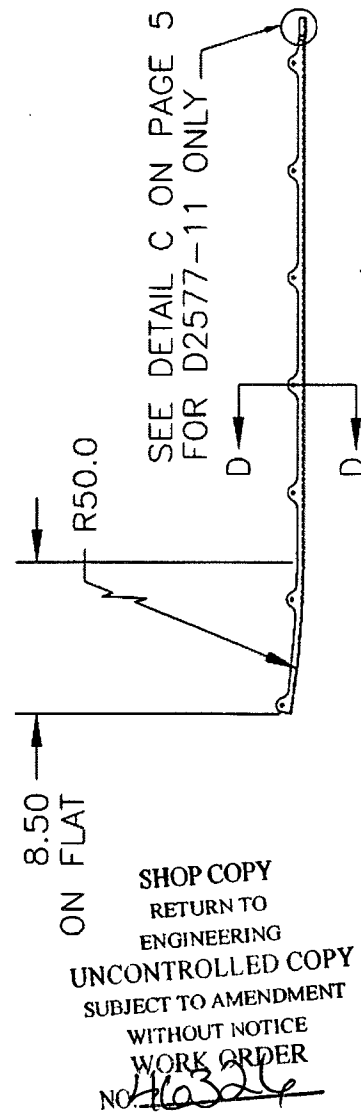
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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2577 | REV. E SHEET 2 OF 5 |
| DATE 00.09.22 | | TITLE WEARSHOE | SCALE 1:10 |



D2577-101 FLAT PATTERN
BREAK ALL SHARP CORNERS 0.010 TO 0.020
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2577-11 & D2577-13 LONGITUDINAL BEND
MAKE FROM D2577-101
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
00 09 26

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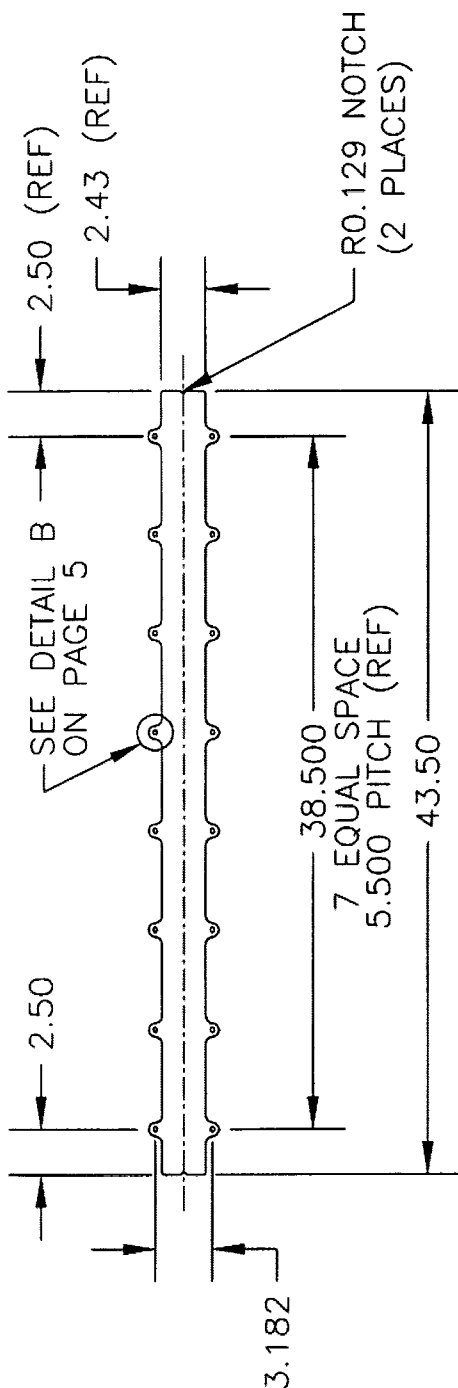
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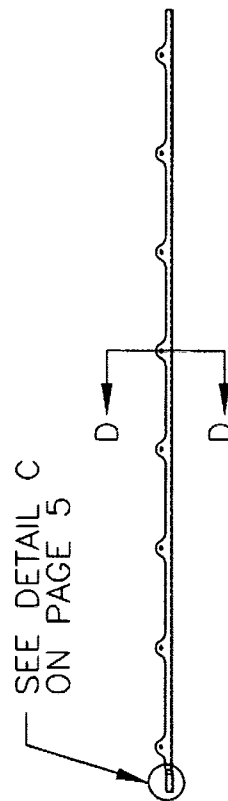
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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2577 | REV. E SHEET 3 OF 5 |
| DATE 00.09.22 | | TITLE WEARSHOE | SCALE 1:10 |

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D2577-5 FLAT PATTERN



D2577-5 LONGITUDINAL BEND



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NO. 46326

D2577-5 WEARSHOE
BREAK ALL SHARP CORNERS 0.010 TO 0.020
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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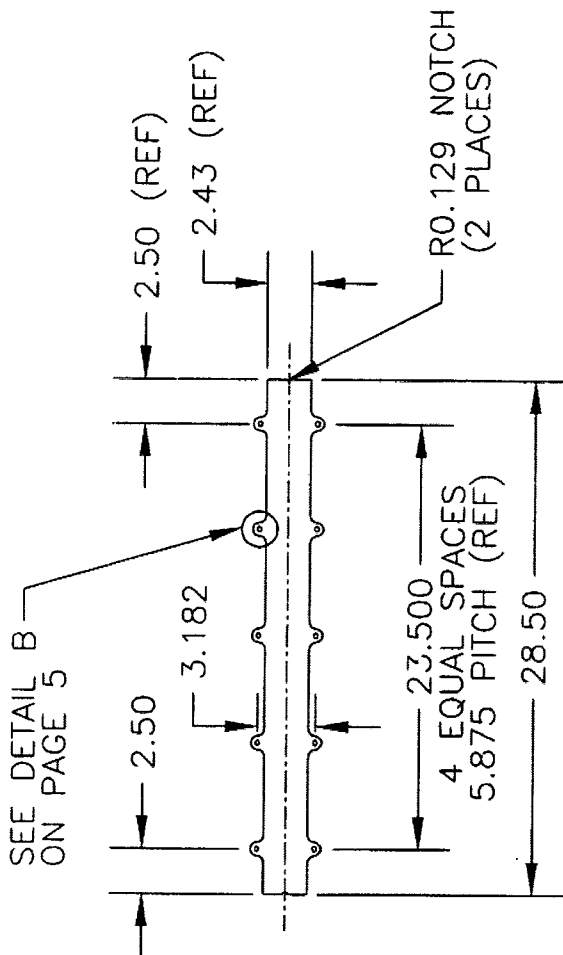
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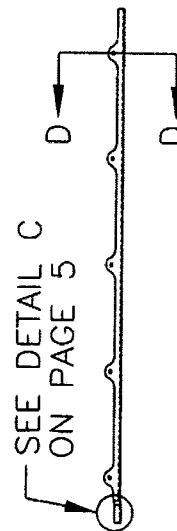
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| CHECKED # | APPROVED # | DRAWING NO. D2577 | REV. E SHEET 4 OF 5 |
| DATE 00.09.22 | TITLE WEARSHOE | | SCALE 1:10 |

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00 09.26

D2577-7 FLAT PATTERN



D2577-7 LONGITUDINAL BEND



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NO. 410326

D2577-7 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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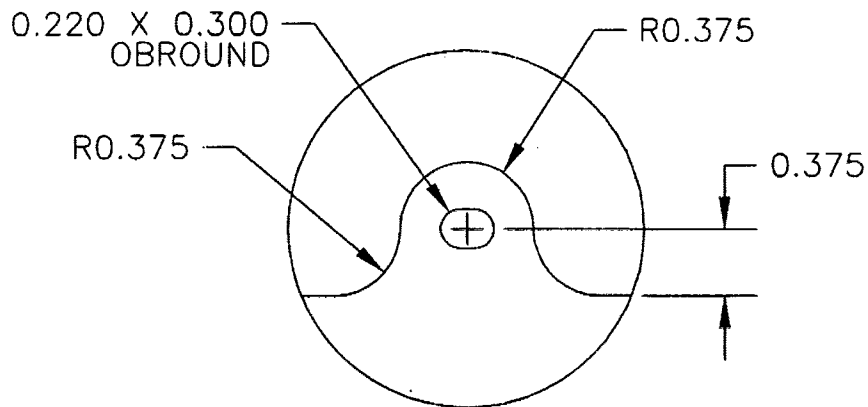
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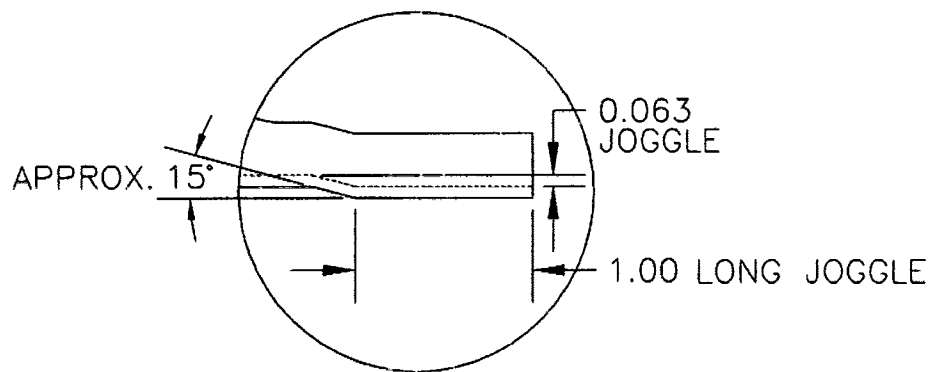
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| DATE 00.09.22 | | TITLE WEARSHOE | SCALE 1:10 |

DETAIL B (SCALE 1:1)

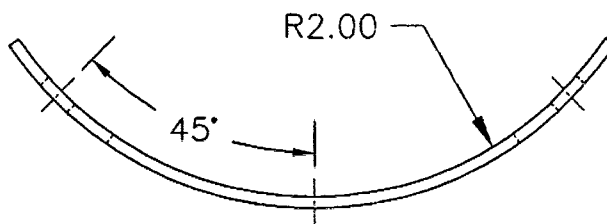
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DETAIL C (SCALE 1:1)



SECTION D-D (SCALE 1:1)



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